



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-121
Job Sheet 166870



Part No: D350-591-121

Job Qty: 5 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 10/18/17

Job Tracking No:

Due Date: 10/25/17

Created By: Mario Poulin

Type: AOG

Description:

Customer: Helinet Aviation Services LLC (CHNET01)

16303 Waterman Drive Van Nuys, CA, 91406 USA ph:(818) 902-0229

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	5 Ea		10/24/17	0.00	0.00	Start Up Large Fab2	2017-10-24
110	Large Fab	5 pcs		10/24/17	0.00	3.40	Large Fab 8	2017-10-24
120	CNC Bend Skid tubes	5 pcs		10/24/17	0.38	1.46	CNC Bend Skid tube	17-10-24
122	QC	5 pcs		10/24/17	0.00	0.00	QC5	17-10-24
126	Large Fab	5 pcs		10/24/17	0.00	3.40	Large Fab 8	2017-10-24
130	QC	5 pcs		10/24/17	0.00	0.00	QC5	
140	Large Fab	5 pcs		10/24/17	0.00	3.40	Large Fab 2	2014-10-24
150	QC	5 pcs		10/24/17	0.00	0.00	QC9	17-10-25
160	QC	5 pcs		10/24/17	0.00	0.00	QC5	17-10-25
170	HandFinish	5 pcs		10/24/17	0.00	0.93	HandFinish1	17-10-25
180	QC	5 pcs		10/24/17	0.00	0.00	QC7	17-10-25
190	Large Fab	5 pcs		10/24/17	0.00	3.40	Large Fab 2	17-10-25
220	QC	5 pcs		10/24/17	0.00	0.00	QC10	AUG 27 2017
230	QC	5 pcs		10/24/17	0.00	0.00	QC5	
240	HandFinish	5 pcs		10/24/17	0.00	0.93	HandFinish1	
250	Powdercoat	5 pcs		10/24/17	0.00	0.81	Powdercoat1	
260	HandFinish	5 pcs		10/25/17	0.00	0.93	HandFinish3	
270	QC	5 pcs		10/25/17	0.00	0.00	QC3	
280	Packaging	5 pcs		10/25/17	0.00	0.00	Packaging1	
290	QC	5 pcs		10/25/17	0.00	0.00	QC4	
295	DC	5 pcs		10/25/17	0.00	0.00	DC	
300	Packaging	5 pcs		10/25/17	0.00	0.00	Packaging3	
310	QC21-FG	5 Ea		10/25/17	0.00	0.00	QC21	

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.

140 - 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033
A/RAluminum Rod 136158 3-Do not Grind Flush

190 - 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod 136158 3-Grind end plate flush.

250 - START TIME: 9:10 OVEN TEMPERATURE: 320° FINISH TIME: 9:40

295 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Process tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>		Process tube	☐	Water Jet	☐	Engineering	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Composite	☐	Supplier	☐		
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Date: _____ Step: _____				MRB (QSI042) Approval																									
Description Work Order: _____		Disposition: _____		Completed By: _____																									
				Lead hand / Supervisor Approval Verification																									
				QC / QA Coordinator Approval																									

Root Cause <table style="width: 100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>	Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐		Wave / Twist in Tube Marks / Chatter OTHER: _____	Change No: _____ Quantity: _____ Operation: _____ Revision: _____ PART NO: _____ Compatible Heli - Access - Step LH - High Gear, Short Step, Float
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2244-116 B150064	3	136	0	0
140-Large Fab	D2850-1 B149901	5	9	0	0
190-Large Fab	D2582 B166018	5	10	0	0
	D2673-34 B160473	5	32	0	0
	MS20600-AD4W3	80	399	0	0
280-Packaging	AN3-37A 5004894	10	40	0	0
	AN4-13A 5004895	5	506	0	0
	AN4-16A 5004902	10	127	0	0
	D2230-1 5004905	5	59	0	0
	D2230-3 5004906	5	132	0	0
	D2732-030 5004907	10	190	0	0
	MS21042L3 5004910	10	960	0	0
	MS21042L4 5004910	15	989	0	0
	NAS1149D0363J 5004912	20	955	0	0
	NAS1149D0463J 5004919	30	2,000	0	0

Part Specifications

Specifications could not be found.

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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REFERENCE ONLY

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hell-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hell-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hell-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2845	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hell-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hell-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hell-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hell-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

Change Record

PAGE 1 OF 1

Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

[illegible]